

Work Order ID 60088

June 24, 2010 9:13:13 AM



Page 1

Item ID: D3262-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Prod 10.00.25

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

Rev E

100

0.00



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut blanks: 6.000" x 0.500" x 5.400" long Bar
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Deburr

0.00

MT 10/07/01

4 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per dwg D3262

0.00

MT 10/07/04

4 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

MT 10/07/04

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60088

June 24, 2010 9:13:13 AM

Page 2

Item ID: D3262-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 6/24/10

Start Qty: 4.00

Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

mk 10/07/05

4

x



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: BARCLAY 0.00

0.00



Packaging

Memo

0.00

Packaging

6/27/05 (4)

150

QC21- Final Inspection - Work Order Release 0.00

0.00



QC

Memo

0.00

Quality Control

10/07/05
CL 10/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:13:12 AM

Page 1 / 1

Work Order ID: 60088

Parent Item: D3262-3

Parent Item Name: Cap



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP CE105.03.100 Removed P/O for liquid penetrant inspection [KJ/JLM]
Rev:D as per ECN 10-571 DD 10.05.10 verified :EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	31.1445	0.96	4.042105	4?		



6061-T6 Bar .500 x 6.00



Location

Loc Qty

Loc Code

MAT05

31.1445

110912

0.5945

112567

30.55

1,8(5)

ISA 10/07/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

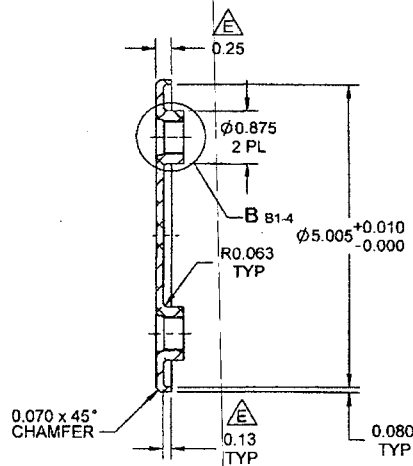
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

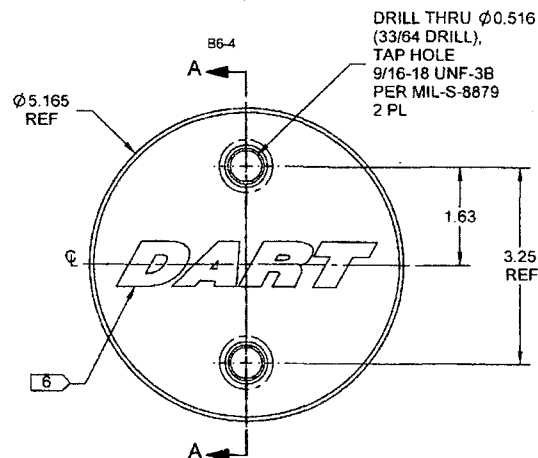
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

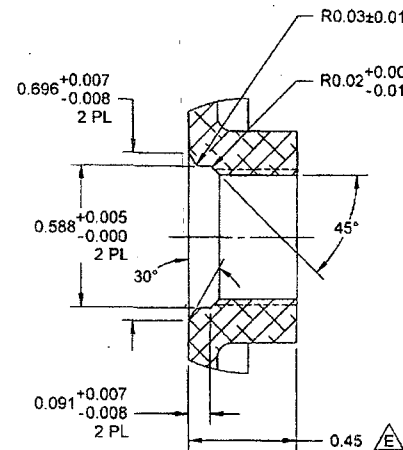
w/o 60088



SECTION A-A C5-4



D3262-3 CAP



DETAIL B C7-4
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
2010-05-07
ANN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
DATE	10.05.03	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE LTD		Work Order:	
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262	Rev: <i>E 4/01</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45° ✓	+/-0.010	.075 x 45	✓			
0.45	+/-0.030	N/A	✓			
R0.063 ✓	+/-0.010	.063	✓			
0.080 ✓	+/-0.010	.079	✓			
0.33	+/-0.030	N/A	✓			
Ø5.005 ✓	+0.010/-0.000	5.005	✓			
0.688	+0.015/-0.000	N/A	✓			
.696	+ .007 - .008	.693	✓			
3.25 ✓	+/-0.005	3.250	✓			
0.875 ✓	+/-0.010	.875	✓			
Ø0.516	+0.005/-0.000	.521	✓			
Ø5.165 ✓	+/-0.010	5.169	✓			
0.083	+0.015/-0.000	N/A	✓			
Ø0.580	+0.005/-0.000	N/A	✓			
Ø.588	+ .005 - .000	.590	✓			
.091	+ .007 - .008	.091	✓			
.13	+/-0.030	.131	✓			
.25	+/-0.030	.249	✓			
.45	+/-0.030	.43	✓			

Measured by: <i>MM</i>	Audited by: <i>MM</i>	Prototype Approval:	N/A
Date: 10/07/04	Date: 10/07/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue - P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	<i>BE</i>